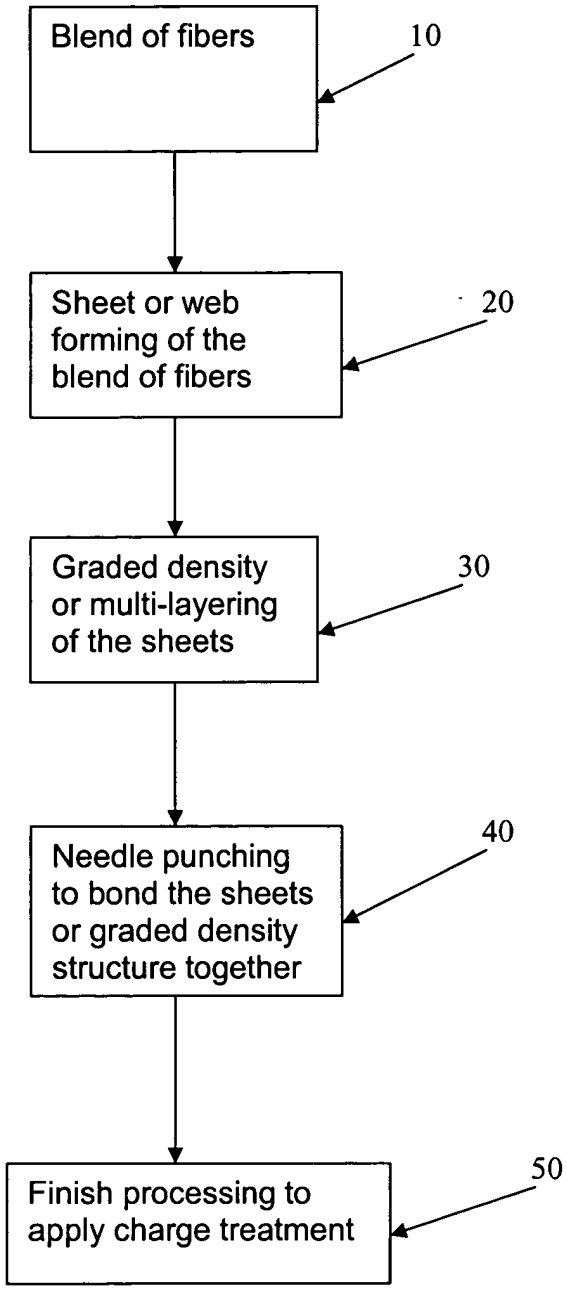
Blend of fibers
10
Sheet or web forming of the blend of fibers
20
Graded density or multi-layering of the sheets
30
Needle punching to bond the sheets or graded density structure together
40
Finish processing to apply charge treatment
50

FIG. 1